



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2646

Job Sheet 203405



S242398

DAS
21
9-88

Part No: D2646

Job Qty: 50 pcs

Part Name: Aft Cap



Part Weight: 0 lbs

Job Created: 11/19/19

Due Date: 12/27/19

Type: Stock

Status: New

Priority: Medium

Job Tracking No:

Created By: Chantal Lavoie

Description:

Note: DWG REV C IPP: G 05.08.22 Hole size revised in Step 5 KJ/JLM IPP Rev:H Changed Inserts 07-02-19 JLM
IPP rev I changed inserts 07.06.11 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
100	Purchasing	50 pcs	12/27/19	12/27/19	0.00	0.00	Purchasing - 1		DEC 19 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	50 pcs	12/27/19	12/27/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		DEC 19 2019
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S242398



Part: D2646

Job No: 203405

Serial No/Batch: S242398

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/19/19

Plex 11/19/19 7:40 AM Dart.Lavoie.Chanta

				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120 QC 6	50 pcs	12/27/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
130 Small Fab - 2 - B4B	50 pcs	12/27/19	0.00 2.01	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				Small Fab - 9 - B4B	
140 QC 5	50 pcs	12/27/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	

DAS
81
9-89

JAN 10 2020

DAS
58
9-89

JAN 10 2020

DAS
82
9-89

					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150	Handfinish - 1-1 Chemical-B4B	50 pcs	12/27/19	0.00 1.78	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	Powdercoat - 1 White GI(A)-B4B	50 pcs	12/27/19	0.00 0.71	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170	QC 3	50 pcs	12/27/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	

DAS 40
JAN 13 2020 9:40

ll 20-2-14

BFB20-02-21

ll 20-2-24

DAS 15
9-89

					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
180	Small Fab - 3 - B4B	50 pcs	12/27/19	0.00 2.01	Small Fab - 1 - B4B	ul 20-2-21
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
190	QC 5	50 pcs	12/27/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
200	Packaging 3-1 - Stock - B4B	50 pcs 20 pcs DAS 28 9-89	12/27/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	DAS 28 9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	

					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-88
210	QC 21 - SA	50 pcs	12/27/19	0.00 0.00		

MAR 02 2020

FP001

Part Op 100 - (Purchasing) Issue P/O: _____ 1-Spin as per Dwg D2646 2-Material release note required Vendor:

Descriptions: Sieg's Manufacturing

110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure Material Release Note is attached

120 - (QC6- All purchased or subcontracted products)

130 - (Small Fab) 1-Drill using DT8026 as per Dwg D2646. 2-Open holes to .297 as per Dwg D2646. 3-Deburr

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Chemical Conversion Coat per QSI005 4.1)

160 - START TIME: 2:10 Oven Temp: 320° Finish Time: 2:40 5235590

170 - (QC3- Inspect Part Finish)

180 - (Small Fab) Install inserts as per Dwg D2646

190 - (QC5- Inspect part completeness to step on W/O)

200 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001

210 - (QC21- Final Inspection - Work Order Release)

Job BOM

5014616

Part / Item	Component Name	Quantity	Operation
D2646P	Aft Cap	50 pcs (1 ea)	100-Purchasing
ALS7-1032-130	Rivnut	100 Ea (2 ea)	180-Small Fab - 3 - B4B

Container

5242386

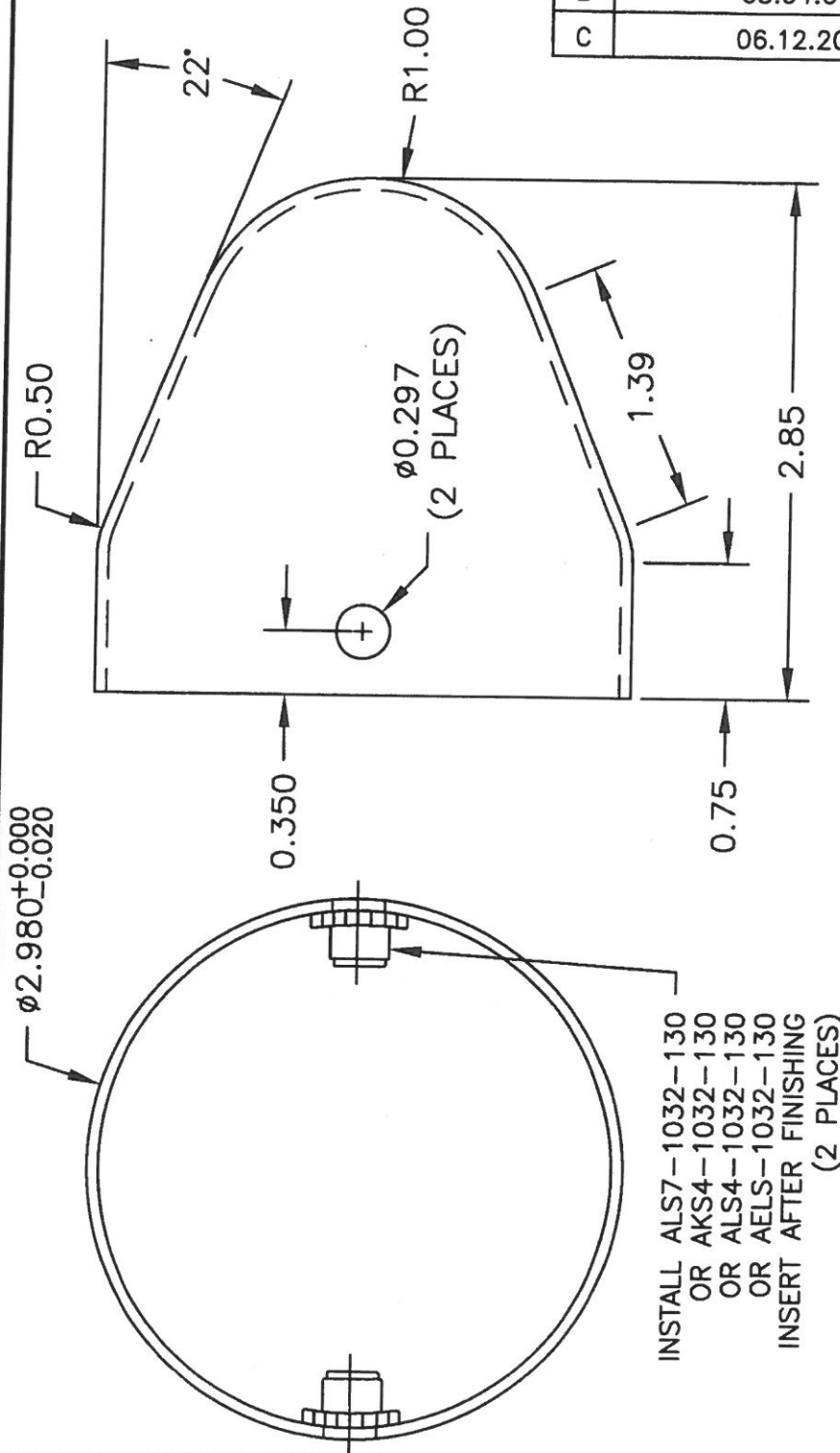
5234264

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2646P	50	0	0
180-Small Fab - 3 - B4B	ALS7-1032-130	100	937	0
Part Specifications				
Specifications could not be found.				

Plex 11/19/19 7:40 AM Dart.Lavoie.Chantal

DART

DESIGN DS		DRAWN BY PH		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2646	
DATE 06.12.20				REV. C SHEET 1 OF 1	
		TITLE AFT CAP		SCALE 1:1	
A	97.03.25		NEW ISSUE		
B	05.04.01		CHANGE TO CLOSED INSERTS		
C	06.12.20		CHANGE TO OPEN ENDED INSERTS		



RELEASED

07.02.12

D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB045144**



Supplier: SIE001-VC
Sieg's Manufacturing Ltd.
6236 - 205 Street
Langley
BC
V2Y 1N7 Canada
Phone: 604 530 7455
Fax: 604 530 7490

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045144

PO Date: 11/19/19

Due Date: 12/10/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

NOV 20 2019

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	203405	D2646P	D2646			AFT CAP	Firmed	-	12/10/19	50 Ea	0 Ea	50 Ea	\$5.90/Ea	\$295.00
						AS PER DWG D2646 REV. C	Yse							
													Grand Total:	\$295.00

DEC 19 2019

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 11/19/19 8:13 AM Dart.Lavoie.Chantal



Sieg's Manufacturing Ltd.
6236 205 Street Langley, BC Canada V2Y 1N7
Ph: (604) 530-7455
Website: www.siegsmf.com

Packing Slip

Packing Slip No.: 2507

Date: 12/12/19

Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Chantal Lavoie 1270 Aberdeen Street Hawkesbury, ON K6A 1K7	Dart Aerospace Ltd. Chantal Lavoie 1270 Aberdeen Street Hawkesbury, ON K6A 1K7
Order No.: POHB045144	Sold By: Kale Quewezance
Shipped By: FedEx	Ship Date: 12/12/19
Tracking No.:	

Item No.	Unit	Description	Quantity
1	each	D2646P Aft cap	50
RECEIVED DEC 19 2019 DART AEROSPACE LTD.			
Comment:			



Sieg's Manufacturing Ltd.
Quality Metal Spinning

6236 205 Street Langley, B.C. Canada V2Y 1N7
Ph#: (604)530-7455 info@siegsfmfg.com

INSPECTION REPORT

Date: December 12 2019
Customer: Dart Areospace
Packing Slip: 2507

Part#:	Quantity	Material	Check holes	Insp. By.
D2646P	50	14g aluminum 1100-0	N/A	KQ

Material Certification Attached: ____yes__

MILL TEST CERTIFICATE

We hereby certify that the material detailed below has been inspected & tested and conforms to the requirements of the specifications herein.

PAGE : Page 2 of 2
CERT NO : 18-1597
DATE : 12/18/2018

MATERIAL & SPECIFICATION										COUNTRY OF ORIGIN		REFERENCE NUMBER			
Aluminium Circles, Sheets										Hong Kong		A18121368			
ITEM	DESCRIPTION & SIZE	ALLOY & TEMPER	QTY. lb.	TAG NO	TENSILE Strength ksi UTS	EARING %	ELONG. %	CHEMICAL COMPOSITION %							
								Fe	Si	Mn	Cu	Mg	Cr	Pb	Al (Bal.)
11	Aluminium Circles 0.125" x 37.500"	1100 0	3651	IP18024793 IP18024974 IP18024975	13.0 12.6 12.6		39.2 39.1 39.1	0.45 0.43 0.43	0.14 0.13 0.13						99.33 99.37 99.37
12	Aluminium Circles 0.074" x 25.750"	3002 0	875	IP18005467	12.6		36.1	0.075	0.034	0.12	0.085	0.1			99.52
13	Aluminium Circles 0.063" x 11.750"	3003 0	1814	IP18025521	16.1	3.4	35.8	0.64	0.24	1.08					97.90

MILL TEST CERTIFICATE

We hereby certify that the material detailed below has been inspected & tested and conforms to the requirements of the specifications herein.

PAGE : Page 1 of 2
CERT NO : 18-1597
DATE : 12/18/2018

MATERIAL & SPECIFICATION										COUNTRY OF ORIGIN		REFERENCE NUMBER			
Aluminium Circles, Sheets										Hong Kong		A18121368			
ITEM	DESCRIPTION & SIZE	ALLOY & TEMPER	QTY. lb.	TAG NO	TENSILE Strength ksi UTS	EARING %	ELONG. %	CHEMICAL COMPOSITION %							
								Fe	Si	Mn	Cu	Mg	Cr	Pb	Al(Bal.)
1	Aluminium Circles 0.051" x 8.500"	1100 0	2306	IP18025387	13.0		39.9	0.51	0.15						99.27
2	Aluminium Circles 0.051" x 14.000"	1100 0	3679	IP18024478 IP18024479	13.0 13.4	2.7 3.0	34.4 34.5	0.43 0.43	0.13 0.13						99.38 99.38
3	Aluminium Sheets 0.051" x 144.000" x 48.000"	1100 0	2967	CL18881245	13.1		39.7	0.43	0.13						99.37
4	Aluminium Circles 0.063" x 19.000"	1100 0	4700	IP18025345 IP18025363	13.5 13.5		34.2 37.2	0.45 0.45	0.15 0.15						99.32 99.32
5	Aluminium Circles 0.063" x 33.000"	1100 0	1874	IP18025023 IP18025024	13.0 13.0		38.1 38.1	0.5 0.5	0.16 0.16						99.27 99.27
6	Aluminium Sheets 0.063" x 120.000" x 36.000"	1100 0	2447	CL18881280	12.6		41.3	0.5	0.16						99.27
7	Aluminium Sheets 0.063" x 120.000" x 48.000"	1100 0	5395	CL18881225 CL18881226	13.1 13.0		40.4 38.2	0.43 0.43	0.13 0.13						99.37 99.37
8	Aluminium Circles 0.080" x 31.000"	1100 0	2224	IP18024905	12.5		42.4	0.44	0.15						99.35
9	Aluminium Circles 0.080" x 31.000"	1100 0	0	IP18024906	13.5		40.0	0.48	0.15						99.26
10	Aluminium Circles 0.090" x 42.000"	1100 0	2745	IP18024809 IP18025468	12.8 13.1		38.3 41.1	0.45 0.48	0.14 0.16						99.33 99.26

For Meyer Aluminum Blanks, Inc.

Anne Timmon
2019-01-16
08:40:52